

Work Order ID 57226

March 30, 2010 11:31:28 AM



Page 1

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 30/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 08/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Spa 10-03-30

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3571

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.90 " long

DT 10/03/30 10 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA675 Rev: *AA* & Dwg D3571 Rev: *A* 12-Deburr

MV= 10/04/06

10 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MV= 10/04/06

10 0

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Y.A 10/04/07

10 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10/04/07

x10 0

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

2:15pm

FINISH TIME:

1:45pm

OVEN TEMPERATURE:

320°F

=> 10/04/07

(x10) 0

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-4-8 10

170

Identify as per dwg & Stock Location: 245A

0.00



Packaging

Memo

0.00

Packaging

Per 4/9 10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12
MF 10-4-9

Picklist Print

March 30, 2010 11:31:28 AM

Page 1

Work Order ID: 57226

Parent Item: D3571-1

Parent Item Name: Guide

Comments: IPP Rev:A New Issue 07-02-01 JLM

Start Date: 30/03/2010

Required Date: 08/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M606IT6B0.750X01.50 0		Purchased	No			100	f	6.2559	2.5368			



6061-T6 Bar .750 X 1.50



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT02	6.25589949	
110167	6.25589949	

*Jan 10.03.30
This Butel only.*

6061-T6 Bar .750 X 2,000

M IIII448

2.5368(f) DIP 10/03/30

DART AEROSPACE LTD		Work Order:	
Description: Guide		Part Number:	D3571-1
Inspection Dwg: D3571	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.699	✓			
Ø1.00 Depth 100	+/-0.010	.999 x .10	✓			
2.75	+/-0.030	2.751	✓			
1.38	+/-0.030	1.379	✓			
1.25	+/-0.030	1.250	✓			
0.63	+/-0.010	.623	✓			
0.031 chamfer	+/-0.010	.030	✓			
Ø0.500	+0.006/-0.001	Ø.500	✓			
Ø0.201	+0.005/-0.001	.201	✓			
R0.25	+/-0.030	R.250	✓			
0.260	+0.000/-0.010	.260	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø.385 x 100°	✓			
0.125	+/-0.010	.130	✓			
2.250	+/-0.010	2.242	✓			
0.250	+/-0.010	.252	✓			
0.188	+/-0.010	.187	✓			
0.063 chamfer	+/-0.010	.063	✓			

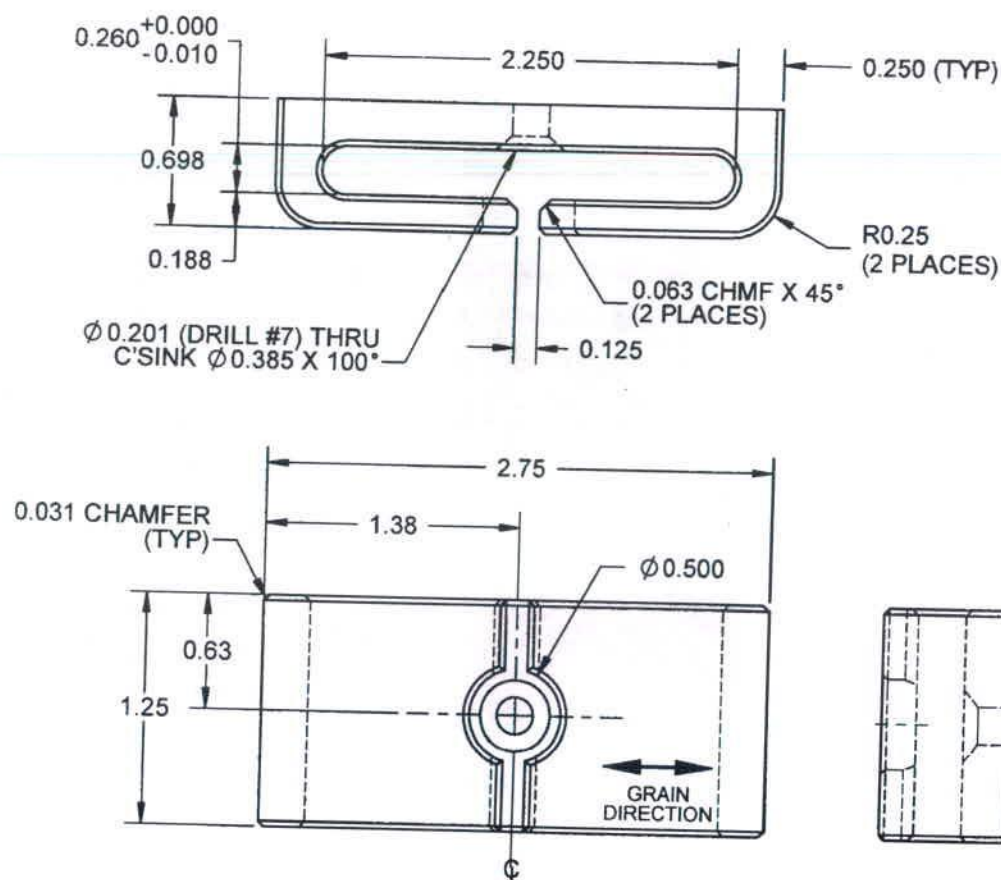
Measured by: <i>MMJ</i>	Audited by: <i>H.A</i>	Prototype Approval:	N/A
Date: <i>10/04/06</i>	Date: <i>10/04/07</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	<i>[Signature]</i>



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DATE 07.01.29		TITLE GUIDE	SHEET 2 OF 2 SCALE 1:1

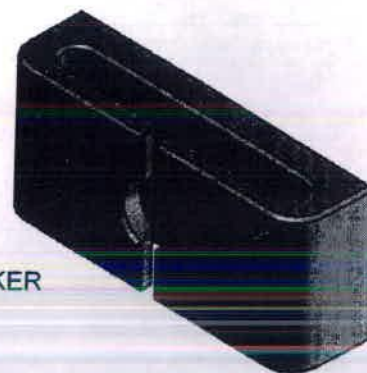
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07.04.12 *[Signature]*



D3571-3 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

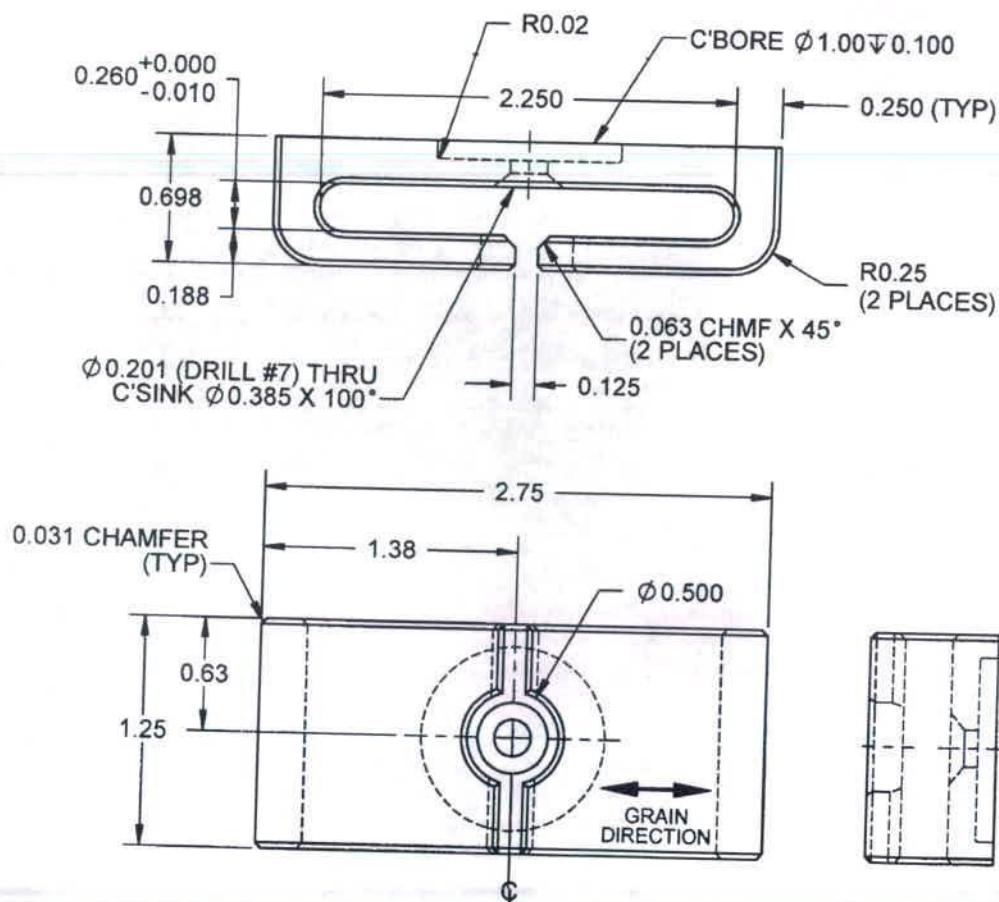


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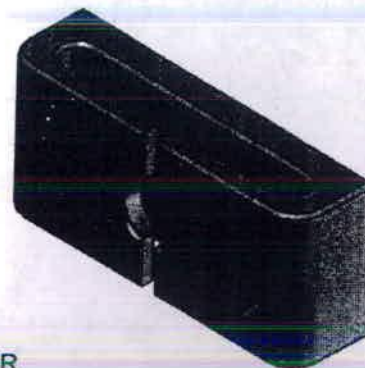
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DATE 07.01.29		TITLE GUIDE	SHEET 1 OF 2
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	SCALE 1:1

RELEASED07.04.12 *[Signature]***D3571-1 GUIDE****NOTES:**

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